

Tuesday, June 16, 2015 11:05:04 AM

133736

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Upper Blade Support Ass'Y

Stop *NS2*

Start Date: 6/16/2015 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 6/16/2015 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: **Process Plan:** MCS

Date: JUN 17 2015

Tooling:

Date: _____

Run Start *NR1*

QC: _____

Date: _____ **SPC (Y/N):** _____

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 133736

Tuesday, June 16, 2015 11:05:04 AM

133736

Page 2

Item ID: PB67-43001-75 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Blade Support Ass'Y
 Start Date: 6/16/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 6/16/2015 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- put screws in nut plates before to keep thread cleanSTART TIME: <u>1:30p</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>2:20p</u>								

140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

150	Identify as per dwg & Stock Location: <u>W/A</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

38
AUG 10 2015

MF 15-8-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 133736

Tuesday, June 16, 2015 11:05:04 AM

133736

Page 3

Item ID: PB67-43001-75

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Upper Blade Support Ass'Y

Stop ***NS2***

Start Date: 6/16/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCJ

AUG 11 2015

MC

15-8-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER :																					

Picklist Print

Tuesday, June 16, 2015 11:05:07 AM

Work Order ID: 133736

133736

Parent Item: PB67-43001-75

PR67-43001-75

Parent Item Name: Upper Blade Support Ass'Y

Start Date: 6/16/2015

Required Date:

Start Qty: 6.00

Required Qty:

Comments: IPP Rev:A 08-07-17 new issue DD verified by:ec
10.09.30 per rev C dwg EC verified by:DD

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issue
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	---------------

D3450-1

Manufactured

No

100

Each

2.0000

1

6

D3450-1

Reinforcement Plate

Location

Loc Qty

Loc Code

Mezz2

112993

2

2

100

Each

4.0000

2

12

PB67-43001-167

Manufactured

No

PB67-43001-167

Side Plate

Location

Loc Qty

Loc Code

Mezz2

99997

4

4

100

Each

12.0000

1

6

PB67-43001-169

Manufactured

No

PR67-43001-169

Long Support Plate

Location

Loc Qty

Loc Code

Mezz2

112994

12

12

100

Each

63.0000

6

36

PB67-43001-171

Manufactured

No

PR67-43001-171

Mounting Plate

Location

Loc Qty

Loc Code

Mezz2

112996

63

63

MF 15-7-13

9 X 134614

DQA: _____ Date: _____



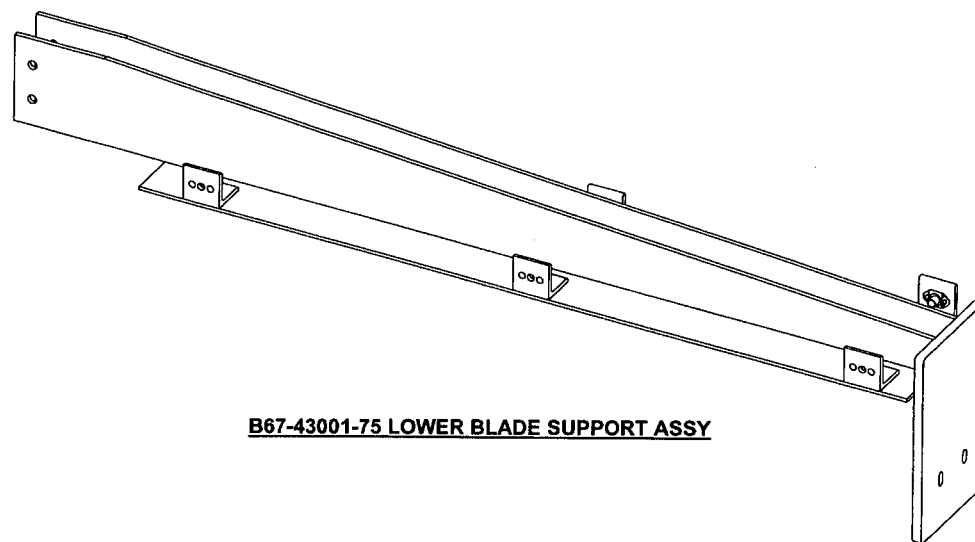
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OTHER : ☐																									

ITEM	QTY -75	P/N	DESCRIPTION
1	X	B67-43001-75	LOWER BLADE SUPPORT ASSY
3	2	B67-43001-167	SIDE PLATE
4	1	B67-43001-169	LONG SUPPORT PLATE
5	6	B67-43001-171	MOUNTING PLATE
6	1	D3450-1	REINFORCEMENT PLATE
8	12	MS20426AD3-4	RIVET
9	6	MS21075L3	NUT PLATE



B67-43001-75 LOWER BLADE SUPPORT ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

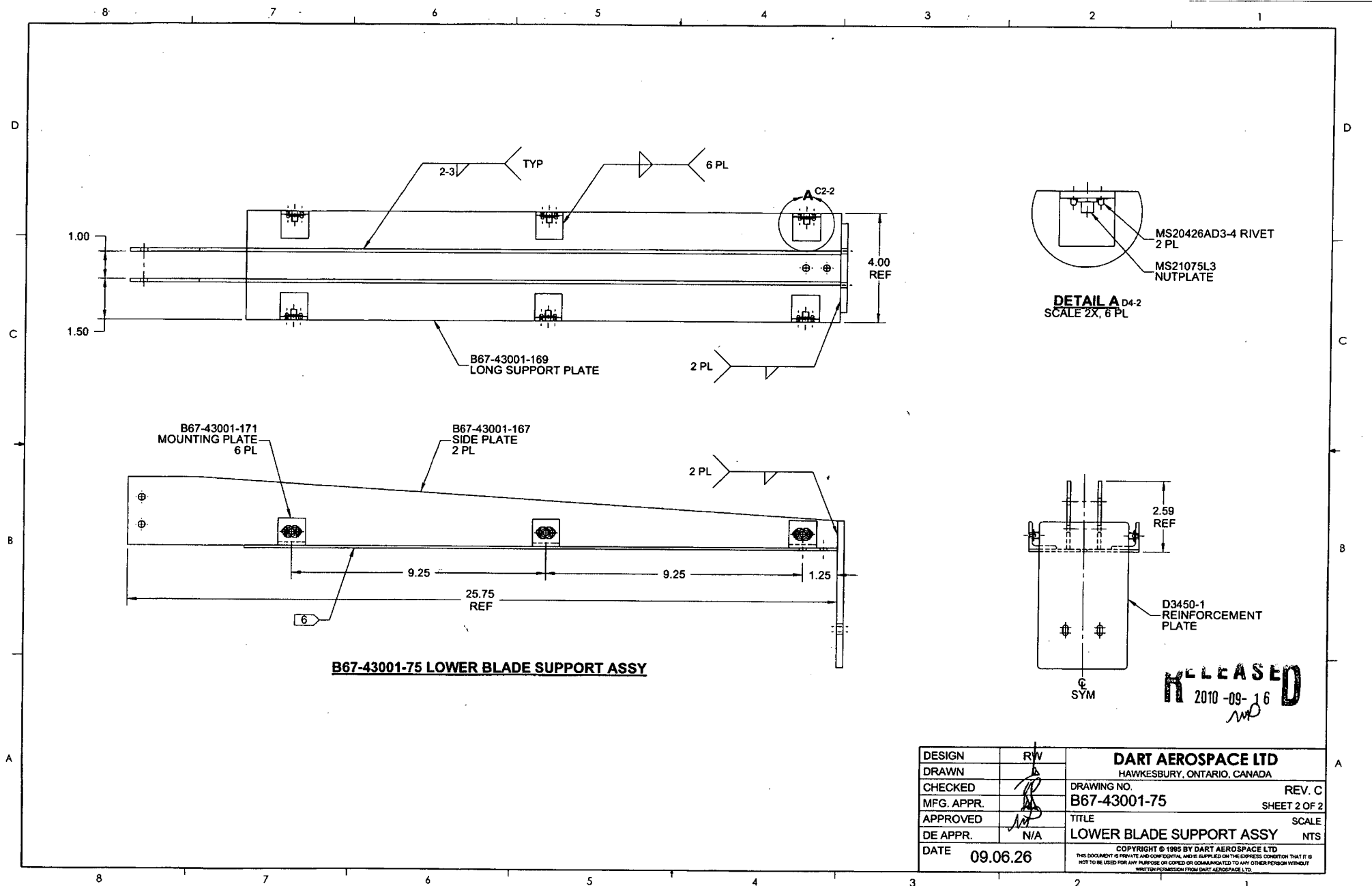
NO. 133 936 MLS
15-06-17

RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-75" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.20 lbs
- 8) WELDING: PER DART QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.26
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	TS	DRAWING NO.	REV. C	
CHECKED	TS	B67-43001-75	SHEET 1 OF 2	
MFG. APPR.	MP	TITLE	SCALE	
APPROVED	MP	LOWER BLADE SUPPORT ASSY	NTS	
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DATE	09.06.26			



RELEASED
2010-09-16

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-75	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS
DATE	09.06.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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